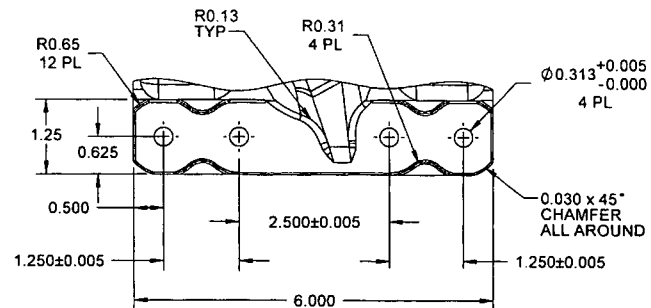
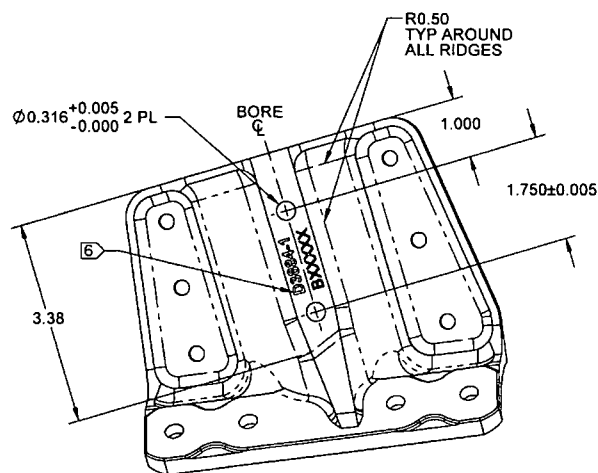


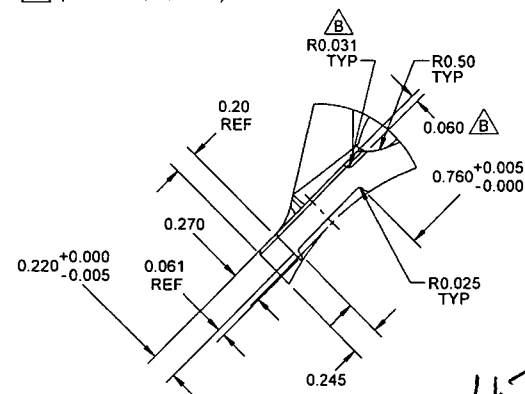
SECTION A-A C4-1



VIEW B-B 83-1
(ROTATED FOR CLARITY)



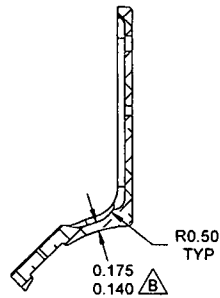
VIEW E-E C6-2



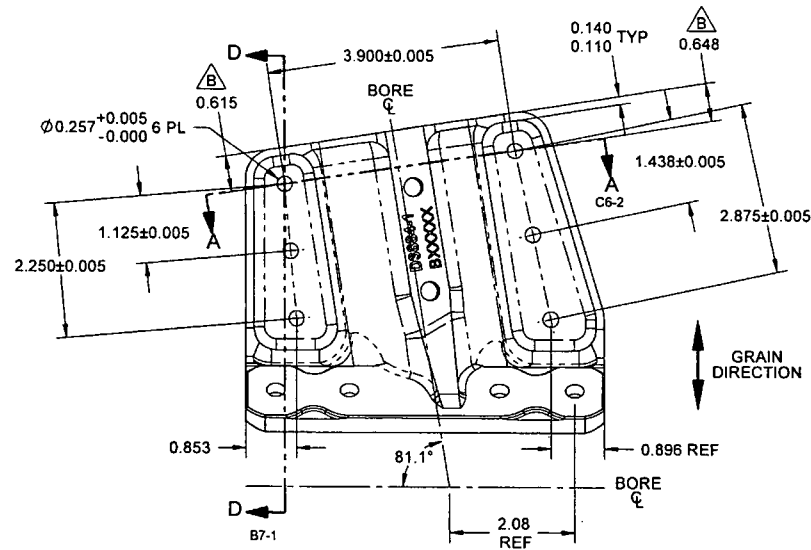
DETAIL C 83-1
SCALE 2X

RELEASED
09/15/10

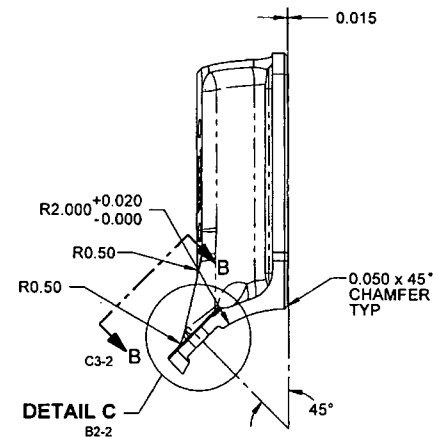
DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED	PH	DRAWING NO.	REV. B
MFG. APPR.		D3884	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		INBOARD SADDLE	NTS
DATE	09.06.30	<small>COPYRIGHT © 2009 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	



SECTION D-D B6-1



**D3884-1 SADDLE, INBOARD LH (SHOWN)
D3884-2 SADDLE, INBOARD RH (OPPOSITE)**



RELEASED
09/07/15/142

47829

NOTES:

- 1) MATERIAL: 7075-T7351 ALUMINUM PER QQ-A-250/12 OR AMS-QQ-A-250/12 OR AMS-QQ-A-250/12 (REF DART SPEC. D6101-017)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX. DEPTH OF 0.010 WITH A MIN. TOOL RAD OF R0.010
- 7) WEIGHT: 0.71 lbs

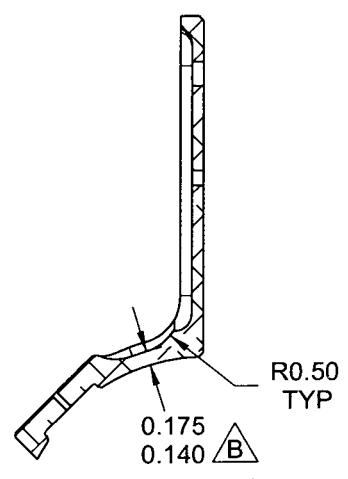
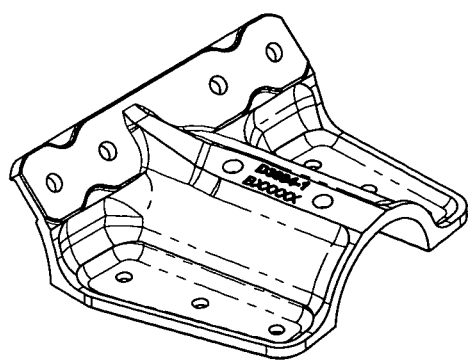
B	D6101-017 WAS D6102-017. ZN A6-1; ADD NOTE. ZN C4-2; ADD R0.031. ZN C2-2; INCREASED TOLERANCE 0.175 WAS 0.185. ZN B7-1; ADD 0.615. ZN C6-1; ADD 0.648. ZN C4-1; ADD 0.250. ZN D6-2; ADD 0.060. ZN C2-2; 0.75 WAS 0.65. ZN D7-2		RF	09.06.30
	NEW ISSUE		RF	09.03.30
REV.	DESCRIPTION		BY	DATE
DESIGN	RF	DART AEROSPACE USA, INC. PORT HADLOCK, WA		
DRAWN	RF			
CHECKED	RF	DRAWING NO.	REV. B	
MFG. APPR.		D3884		SHEET 1 OF 2
APPROVED		TITLE	SCALE	
DE APPR.		INBOARD SADDLE	NTS	
DATE	09.06.30	COPYRIGHT © 2009 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.		

8

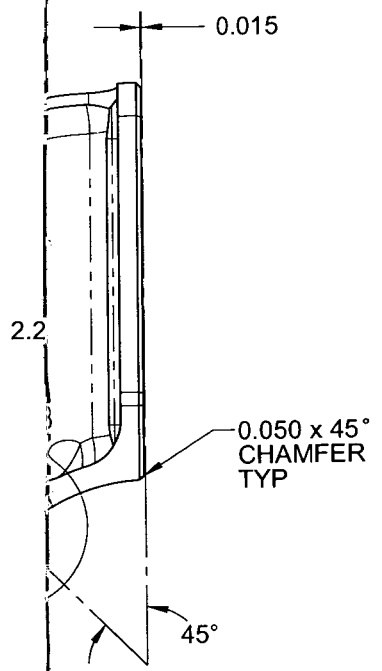
7

2

1



SECTION D-D B6-1



PRELIMINARY

6102-017. ZN A6-1; ADD NOTE. ZN C4-2; 2-2; INCREASED TOLERANCE 0.175 WAS 0.615. ZN C6-1, ADD 0.648. ZN C4-1; 2-2; ADD 0.060. ZN C2-2; 0.75 WAS 0.65. ZN		RF	09.06.05
		RF	09.04.23
DESCRIPTION		BY	DATE
DART AEROSPACE USA, INC. PORT HADLOCK, WA			
DRAWING NO. D3884		REV. B SHEET 1 OF 2	
TITLE INBOARD SADDLE		SCALE NTS	
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NOTES:



- 1) MATERIAL: 7075-T7351 ALUMINUM PER AMS-QQ-A-250/12 (REF DART)
- 2) FINISH: CHEMICAL CONVERSION COAT
POWDER COAT "WHITE" (4.3.5.)
- 3) TOLERANCES: PER DART QSI 018 UNL
- 4) UNITS: INCHES UNLESS OTHERWISE N
- 5) BREAK SHARP EDGES: 0.005 TO 0.010
- 6) IDENTIFICATION: ENGRAVE PART AND
MAX. DEPTH OF 0.01
- 7) WEIGHT: 0.71 lbs

DART AEROSPACE LTD				Work Order:	47829
Description:				Part Number:	D3884-2
Inspection Dwg:	Rev:	DSK:	Rev:	Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article
 ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
A	.886	.906		.896	.896			
B	.843	.863		.854	.855			
C	.791	.811		.801	.801			
D	2.245	2.255		2.250	2.250			
E	1.120	1.130		1.125	1.125			
F	.040X45°	.06X45°		.043X45°	.043X45°			
G	.115	.135		.123	.122			
H								
I								
J								
K								
L								
M								
N								
O								
P								
Q								
R								
S								
T								
U								
V								
W								
X								
Y								
Z								
AA								
AB								
AC								
AD								
AE								
AF								
AG								
AH								
Accept/Reject								

Measured by:	JK	Date:	09/06/05
Audited by:	8P	Date:	09/06/05
Prototype Approval:	9P	Date:	07.06.06




Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	07.11.08	Reformat	KJ/JLM	

DART AEROSPACE LTD				Work Order:	47829
Description:				Part Number:	D3884-2
Inspection Dwg:	Rev:	DSK:	Rev:	Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ **First Article**
☐ **Prototype**

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
A	1.265	1.285		1.265	1.268			
B	2.000	2.020		2.000	2.003			
C	1.526	1.546		1.541	1.543			
D	.140	.165		.152	.151			
E	R.178	R.198		.188	.188			
F	R.470	R.530		.500	.500			
G	.110	.140		.138	.135			
H	.240	.260		.253	.254			
I	.720	.780		.765	.765			
J	2.826	2.886		2.875	2.875			
K	1.220	1.280		1.260	1.260			
L	Ø.313	Ø.318		.316	.316			
M	.020x45°	.040x45°		.030x45°	.03x45°			
N	1.245	1.255		1.250	1.250			
O	2.495	2.505		2.500	2.500			
P	6.890	6.010		6.000	6.000			
Q	1.245	1.255		1.250	1.250			
R	.490	.510		.499	.498			
S	.215	.220		.217	.218			
T	.260	.280		.265	.265			
U	.760	.765		.760	.760			
V	.235	.255		.247	.247			
W	.615	.635		.625	.624			
X	Ø.316	.328		.319	.319			
Y	3.350	3.410		3.365	3.365			
Z	.990	1.010		1.002	1.005			
AA	1.745	1.755		1.750	1.750			
AB	.140	.165		.151	.147			
AC	R.470	R.530		.500	.500			
AD	Ø.257	.262		.259	.259			
AE	3.895	3.905		3.900	3.900			
AF	.115	.135		.135	.135			
AG	1.433	1.443		1.438	1.438			
AH	2.870	2.880		2.875	2.875			
Accept/Reject								

Measured by:		Date:	09/06/05
Audited by:		Date:	09/06/05
Prototype Approval:		Date:	09.06.08

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	07.11.08	Reformat	KJ/JLM	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001, Dart Helicopters Services

Drawing Name: SADDLE FITTING

Job Number: 47829

Part Number: D38842

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



**ENGINEERING
APPROVAL**



Comment: SECOND CHECK

UP 09.06.08 LP 09/06/09

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

FL 09/06/09 (2)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M111472

START TIME:

2:00pm

OVEN TEMPERATURE:

320°F

FINISH TIME:

2:30pm

SH

09-06-09

(X2)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



* Give to Jason-M



Comment: INSPECT POWDER COAT

BR

09-06-9

(2)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

Assy on D119-642-213/12

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



POSITIVE RECALL

MF 09-06-23

EFFECTIVE

09.05.11

AUTH

U

RELEASED

DATE

ENG USE ONLY

UP 09.09.02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Sunday, 10/05/2009 7:59:40 AM

Melanie Fauteux

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
 Job Number : 47829
 Estimate Number : 13927
 P.O. Number :
 This Issue : 10/05/2009 S.O. No. :
 Prsht Rev. : NC
 First Issue : // Type : MACHINED PARTS
 Previous Run :
 Written By :
 Checked & Approved By : mf 09-05-10
 Comment : Est Rev:A New Issue 09-05-09 JLM Verified By:EC

Drawing Name : SADDLE FITTING
 Part Number : D38842
 Drawing Number : D3884 PREL
 Project Number : N/A
 Drawing Revision : PREL
 Material :
 Due Date : 17/05/2009



2 Um: Each

Additional Product

PRELIMINARY ISSUE

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D6101017 Saddle Billet



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)
 7075-T7351 6.350 X6.250
 Make from D6101-017 billet for D3884-1/-2
 Ensure that grain is along 6.350 " length
 Batch No: 47460 x

2.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1
 Program Batch No. 47829 Double check by: _____

1-Machine Step No 1 per Folio FA819 and inspect per attached Dimension Sheets
 2-Machine Step No 2 per Folio FA819 and inspect per attached Dimension Sheets
 3-Machine Step No 3 per Folio FA819 and inspect per attached Dimension Sheets
 4-Deburr

3.0 MILLING CONV. CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE
 Machine keyway as per dwg D3884

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE